XX /~1-	Λ.		TT	72122	,
Work	()r	der	11)	72123	ì

Tuesday, July 19, 2011 12:40:03 PM



Page 1

Item ID: D3275-1 Accept Setup Start **Revision ID:** Stop Crossbolt Spacer **Item Name: Start Date:** 7/19/2011 **Start Qty: 160.00 Cust Item ID:** Req'd Qty: 160.00 Required Date: 7/25/2011 **Customer:** Reference: Start Run Date://-07-19 Tooling: **Process Plan:** Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Reject Reject Set Up/ **Tool ID** Tool # Plan Accept Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3275 Rev A1 100 0.00 161 Hardinge CNC LATHE SMALL 0.00 Hardinge Memo Hardinge CNC Lathe Small 1-Turn as per Folio FA469 and Dwg D3275 11/8/10 QC2- Inspect parts off machine FAI/FAIB 110 0.00 161 0.00 Memo Quality Control 158110 PC 11-8-10 120 0.00 QC8- Inspect parts - second check

Quality Control

Memo

0.00

W/O:			W	ORK ORDER CHANGE	ES						
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				· · ·				<u> </u>			
						•					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	s No DC)A:	Date: _			
	R	esolution:	Disposit	ion:	_ QA: N/C (Closed:	osed: Date:				
NCR:	ļ		WORK OR	DER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC Corrective Action Section				Verif	ication	Approval	Approval		
	J. 2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector		
		·									
	1								1		

Work Order ID 72123

Tuesday, July 19, 2011 12:40:03 PM



Page 2

Item ID:

D3275-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crossbolt Spacer

Start Date:

Required Date: 7/25/2011

7/19/2011

Start Qty: 160.00 Reg'd Qty: 160.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Start



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

STOCK IN SKIDTUBE CELL

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Duit Aci	ospace	LIG							
W/O:		Table 1	W	ORK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				,					
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Dispositio	n:	QA: N/C Closed: Date:				
NCR:		.V	VORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section				cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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Picklist Print

Tuesday, July 19, 2011 12:40:09 PM

Work Order ID: 72123

Parent Item:

D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 160.00

Required Qty: 160.00

Comments:

IPP Rev:A□04.10.19□New issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05		Purchased	No		100	f	82.5390	0.2666	44.90105	i	_	



ALUM TUBE .3125 x .058w

Location	Loc Oty	Loc Code
MAT013	82.539	
116793	1.667	
116939	47.972	
117400	32.9	

118438

Page 1

	•											
W/O:		WORK ORDER CHANGES										
Part No: PAR #: Fault Category: Resolution: Disposition: NCR: WORK ORDER NON-CONFORMA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	_ Date: _				
					_ QA: N/C CI	osed:		Date:				
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR	1)						
DATE	STED	Description of NC	Describtion of NC		veri			cation Approval	Approval			
DAIL	SIEP				Sign & Date	Secti		Chief Eng	QC Inspector			
								:				
		·										

DART AEROSPACE LTD	Work Order:	72/23
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
3.180	+/-0.010	3.180						
0.025 - 0.030	N/A	025						
45°	+/-0.01°	450						
Ø0.313	+0.010/-0.005	-311						
0.058	Max = 0.0605 Min = 0.0555	-056						
.1	·							
						,		

Measured by:	12	Audited by:	RC	Prototype Approval:	N/A
Date:	11/8/10	Date:	118.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.19	New Issue	KJ/JLM	
В	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM ,	11
С	09.05.04	Ø0.197 dimension removed	KJ/DD of	
	'	4	1 //	144

W/O:		7772-045	W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		W. Market								
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Ye	es N	o DQA	\ :	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/C	Clos	ed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			tion B		Verification		Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng			n & ate	Section C		Chief Eng	QC Inspector
				to the second se						
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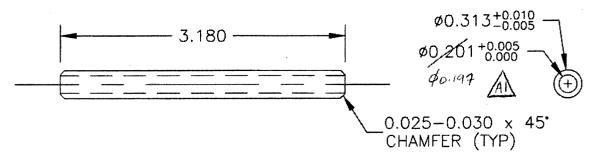
DESIG	'W	DRAWN BY	DART AEROSPACE US	A, INC.
CHECK	ED A	APPROVED	DRAWING NO.	REV. A
	#	#	D3275	SHEET 1 OF 1
DATE			TITLE	SCALE
04.0	3.10		CROSS BOLT SPACER	1:1
Α	ıJ	04.03.10	NEW ISSUE	
Aı	gal	04.10.19	CHANGE MAT'L SPEC	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CUPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 7212-3 Pl 11-67-19



D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6T0313W.058

2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:			V	ORK ORDER CHANGE	S				
DATE	STEP	PROC	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:			NCR: Yes	Vo DQ	A:	Date: _	
		esolution:							
NCR:		W	ORK OR	DER NON-CONFORMAN	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section E			Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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